

WORK INSTRUCTION

Title: **ICV/OCV Lid & Body Seal Flange Groove Width Measurements**

Instruction No. CH.10

Rev. 0, January 2002

Page 1 of 4

• Approved for Use by: Michael R. Brown Effective Date: January 2002

Applicable Drawings:

- 2077-500SNP (Sheet 7) - TRUPACT-II Packaging SARP Drawings
- 707-SAR (Sheet 6) - HalfPACT Packaging SARP Drawings

SARP Requirements:

- Chapter 8.0. Prior to first use and annually thereafter.

Tools Required:

- Pin Gauges (SARP Chapter 8.0)
- C-Clamp 4-in. Minimum
- Softener Blocks (Brass or Aluminum) - 1/4-in. thick x 1-in. x 1-in. minimum
- 6-in. to 10-in. Adjustable Wrench
- Precision Pin (SARP Chapter 8.0)

Spare Parts Required:

- None

Materials Required:

- None

Safety Requirements:

- Safety will be observed in accordance with site requirements.

Prerequisite Conditions:

- ICV and OCA lids have been removed and are on stands.

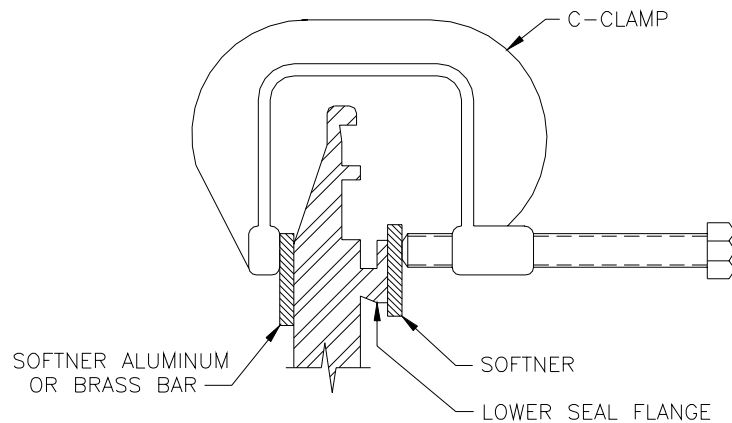
Instruction Steps:

- 1.0 Record all data from this instruction on the attached data sheet (Attachment 2, Work Instruction CH.10, Form 1).
- 2.0 This instruction **is not required to be attached** to the Maintenance Record but may be used as a checklist during performance of maintenance.

- 1.0 At each of the 18 locations (does not have to be exact) insert the appropriate pin gauge for lids and body, then pass precision pin under pin gauge as shown in Attachment 1. See Attachment 1, Figure A, for Lid Groove and Figure B for Body Groove Measurement techniques.
- 2.0 Check completion of each measurement using Attachment 2, Form 1.

NOTE: If any location is unacceptable, proceed to step 3.

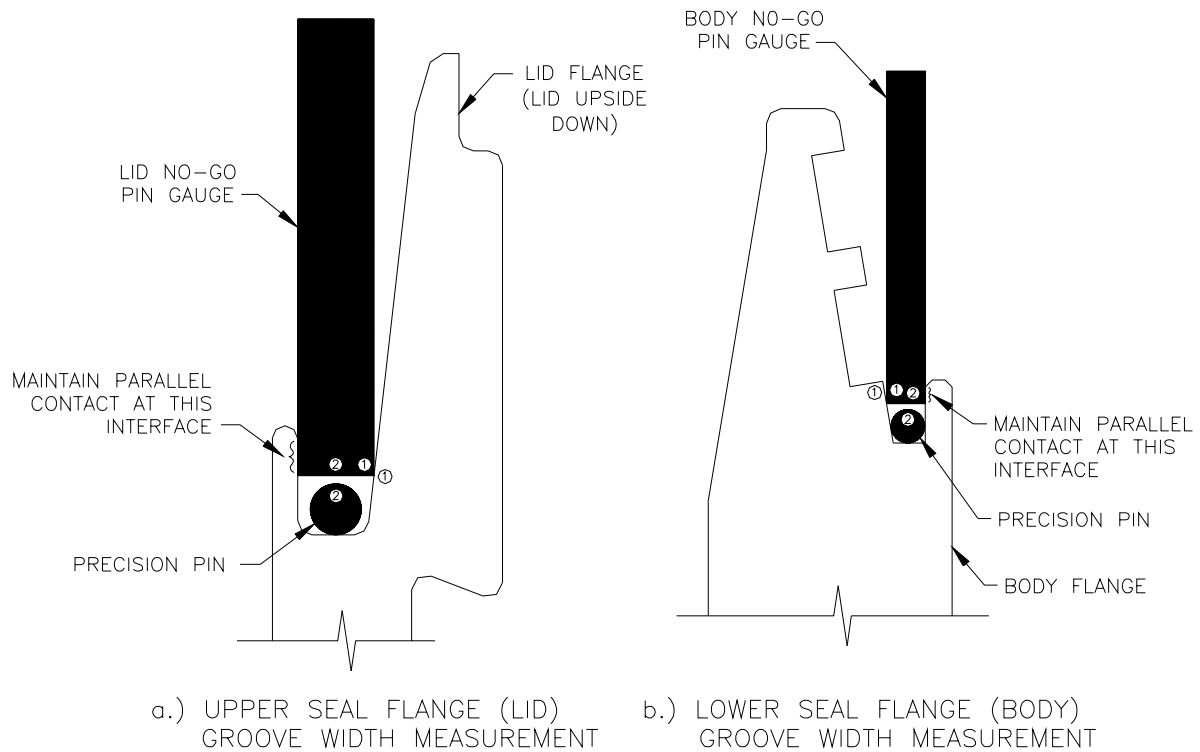
- 3.0 Install Softeners and "C" Clamp as shown in the approximate center of the groove tab and tighten until the clamp will hold the softener in place.
- 4.0 Tighten "C" Clamp in $\frac{1}{2}$ turns and measure groove until in conformance.
- 5.0 Note any deficiencies or adjustments on maintenance record.



Verification Requirements:

- 1.0 Work performed is described on Maintenance Record.
- 2.0 Work instruction is listed on Maintenance Record.
- 3.0 Data sheet is attached to Maintenance Record.
- 4.0 Deficiencies or adjustments documented on Maintenance Record.

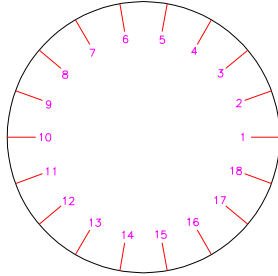
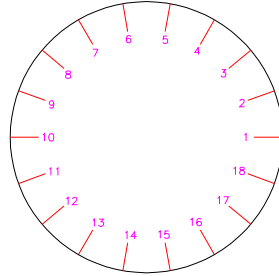
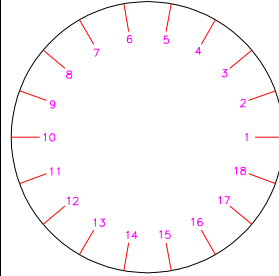
ATTACHMENT 1



NOTES

1. CONTACT AT LOCATION 1-1 AND GAP AT LOCATION 2-2 IS A "NO-GO" CONDITION INDICATING THE GROOVE WIDTH IS ACCEPTABLE.
2. CONTACT OR A GAP AT LOCATION 1-1 AND CONTACT AT LOCATION 2-2 IS A "GO" CONDITION INDICATING THE GROOVE WIDTH IS UNACCEPTABLE.

Attachment 2, Form 1 - Data Sheet - ICV/OCV Lid and Body Flange Groove Widths

Packaging S/N: _____		Date: _____		Job No. _____	
					
ICV LID		ICV BODY		OCV LID	
Loc.	$\sqrt{^*}$	Loc.	$\sqrt{^*}$	Loc.	$\sqrt{^*}$
1.		1.		1.	
2.		2.		2.	
3.		3.		3.	
4.		4.		4.	
5.		5.		5.	
6.		6.		6.	
7.		7.		7.	
8.		8.		8.	
9.		9.		9.	
10.		10.		10.	
11.		11.		11.	
12.		12.		12.	
13.		13.		13.	
14.		14.		14.	
15.		15.		15.	
16.		16.		16.	
17.		17.		17.	
18.		18.		18.	
INSPECTION:		SAT	UNSAT	INSPECTION:	
ICV lid				OCV lid	
ICV body				OCV body	

*Deficiencies/adjustments noted on Maintenance Record

QA: _____ Date: _____

Precision Pin S/N: _____ Cal. Due Date: _____

Pin Gauge S/N: _____ Cal. Due Date: _____

Pin Gauge S/N: _____ Cal. Due Date: _____